

Date: Monday, 23/03/2009 2:10:02 PM  
User: Julie Dawson

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350/212/130 BASKET LID
Job Number	: 46666B		
Estimate Number	: 10193		
P.O. Number	:	Part Number	: D2512
This Issue	: 23/03/2009 S.O. No. :	Drawing Number	: D2512 REVE
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 46537B	Material	:
Written By	:	Due Date	: 31/03/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JUD 09-03-23</u>		
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC Est Rev:O 08-08-29 revE as per dwg DD verified by:EC Est Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .065" wall

Batch: m110839

m110969

m111148 (8.7594) 1

(35.000)

SAD 09-03-25

2.0	D31663	(2.000) Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3166-3

Basket Hoop

~~46666B~~ 46305 1

SAD 09-03-25

3.0	D2506	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2506

Label Plate

B 44275 → 1x

SAD 09/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D2512

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2327-1	Bushing	B 40390 → 2x
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LY 09/03/25

5.0	D22321	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2232-1	Hinge plate	B 39454 → 2x
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LY 09/03/25

6.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2581	Mounting Bracket	B 45684 → 2x
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LY 09/03/25

7.0	M304EX07516F..	Expanded Metal Flat SS
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Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty	Part Number	Description	Batch
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18 sf	M304EX0.75-16F Expanded Metal		M110992 1 SAP 09-03-25
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①

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

SAD 09-03-24

2-Cut (4) D2236 From D3166-3

SAD 09-03-25

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

SAD 09-03-25

①

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

LY 09/03/30 / PD 09-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46666B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Pl 09.04.01*

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*S 02/04/01 @*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*PRESS WASH BR*

*09-04-2*

1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating

2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 *M110939*

1ST COAT:

START TIME:

*14:00*

OVEN TEMPERATURE:

*400°*

FINISH TIME:

*14:30*

*BR 09-04-2*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*Spray paint: M110907*

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 *WW* Batch: *M11013*

*FL 09/04/06*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*S 02/04/06 @*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*46666 9/1/06*

*(ix)*

*cy*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/07 HJ

Job Completion



MF  
09-04-06

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

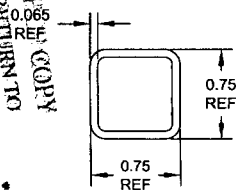
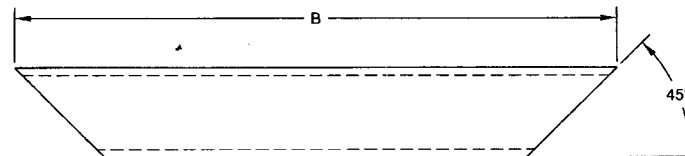
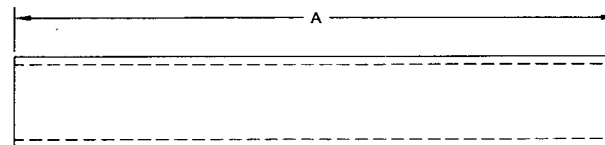
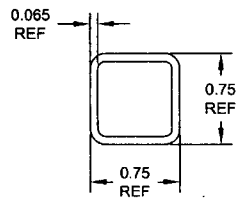
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



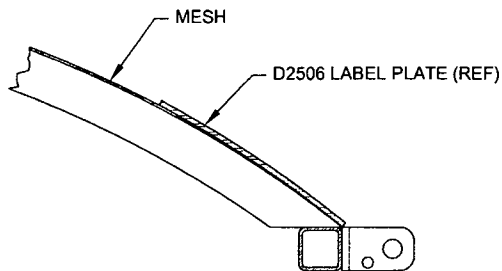
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08-08-21-118

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED FOR CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

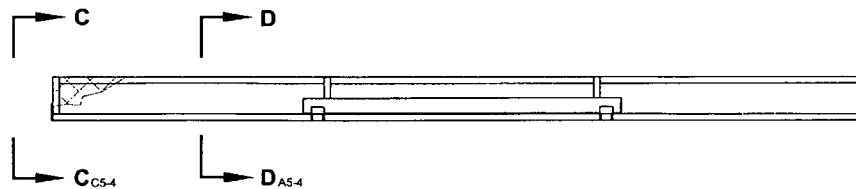
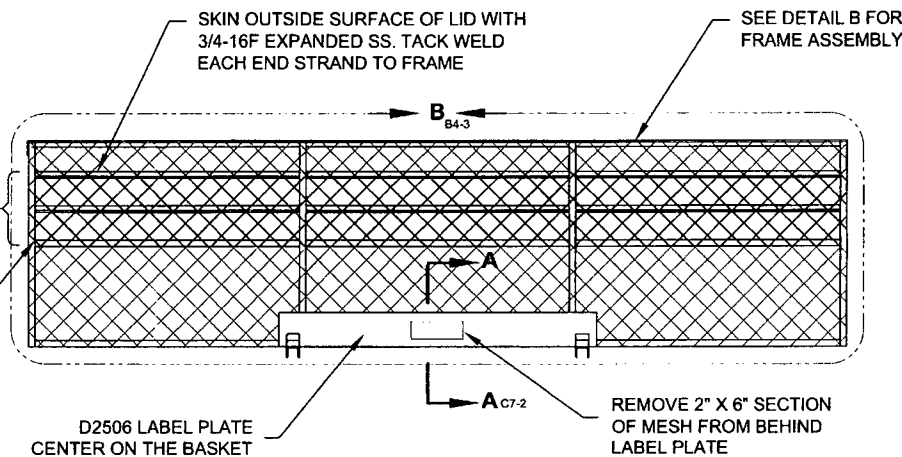
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0.065  
REF



**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



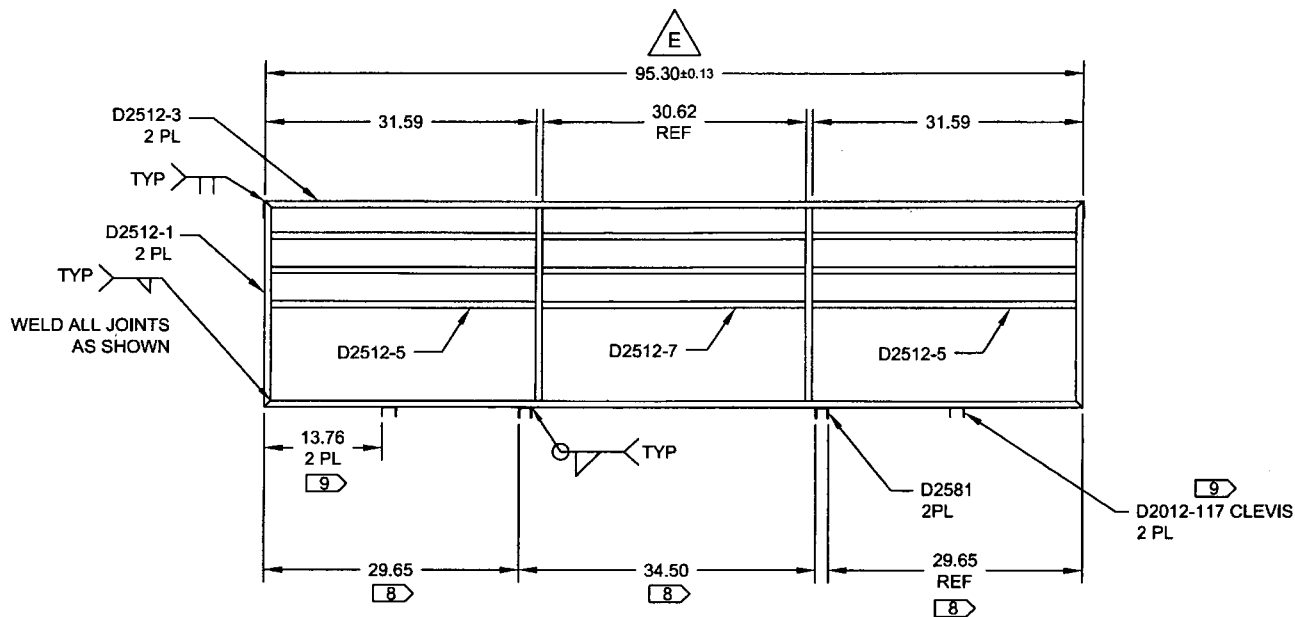
**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

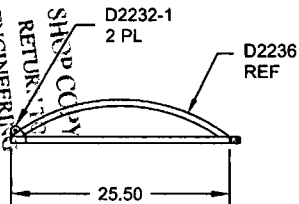
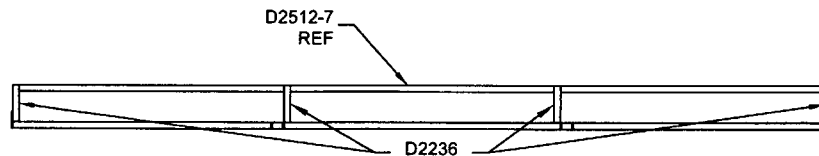
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
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DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



**NOTES:**

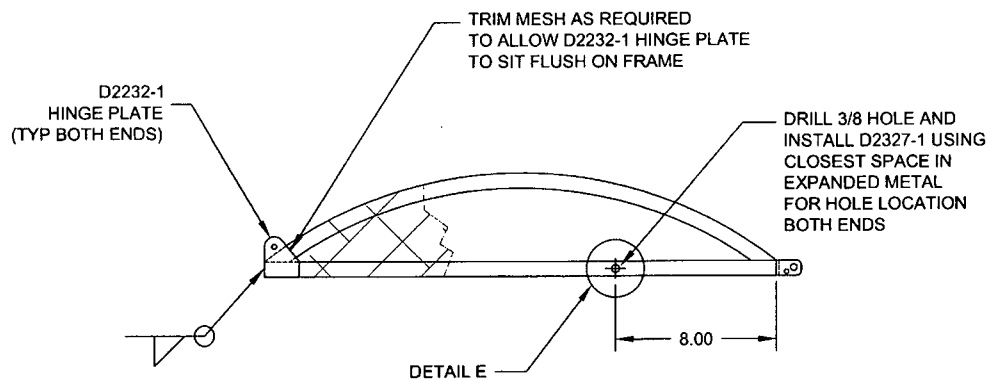
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

**RELEASED**  
08 06 17

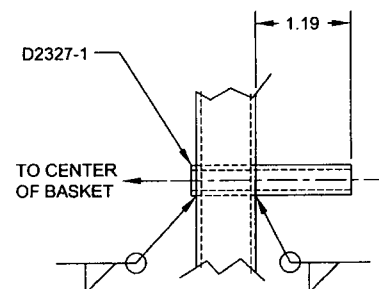
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	B	D2512	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
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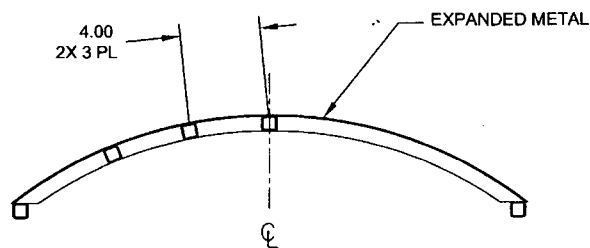
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**VIEW C-C SIMILAR BOTH END RIBS** A5-2







**DETAIL E** C6-4



**SECTION D-D SAME BOTH CENTER RIBS** A4-2

**RELEASED**  
65 55 21/140

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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1